

AMENDMENTS TO THE SPECIFICATION

Cancel the paragraphs from page 4, line 19 to page 5, line 6, and replace with the following:

--Referring in detail to the drawings, Figs. 1 and 2 illustrate a container 10 and Fig. 3 illustrates a container ~~perform~~ preform 110. The container ~~perform~~ preform 110 is injection molded and the body 112 thereof subsequently blow molded to form the container 10 with an expanded body 12.

The container 10 and ~~perform~~ preform 110 are composed of polymeric material, such as homopolymer polypropylene, copolymer polypropylene, polyethylenes, polyethylene terephthalate, and the like. The container 10 and preform 110 generally include the bodies 12, 112 and a neck finish 14 extending therefrom. The container 10 is generally hollow and cylindrical with a longitudinal axis that runs through closed lower ends 16, 116 of the bodies 12, 112 and an open upper end 18 of the neck finish 14. The container 10 is also generally symmetrical along its longitudinal axis, with the exception of external threads 20 and a deflectable closure release 22 that are integrally formed on the neck finish 14.--

Cancel the paragraph at page 6, lines 7-17, and replace with the following:

--There are, however, several differences between the container 10 and preform 110 of the present invention and the child resistant container of the '195 patent. For example, the container 10 is an injection blow molded article, whereas the container of the '195 patent is simply injection molded. The container ~~perform~~ preform 110 is a preformed article or parison, which is injection molded prior to being blow molded. Also,

the container 10 and preform 110 include a longitudinal parting line 40 and a transverse parting line 42 that intersect at the closure release 22. Finally, the container 10 and preform 110 include a smooth pad 44 (not shown in Fig. 2) on the neck finish 14 proximate the closure release 22, wherein the longitudinal parting line 40 is interrupted. This interruption in the longitudinal parting line 40 will be explained in further detail below in reference to the methods and apparatuses of the present invention.--

Cancel the paragraph at page 9, line 17 to page 10, line 3 and replace with the following:

--Fig. 5 also shows the mold bodies 220, 222 having an external pilot surface 250 of the core 244 that cooperates with an internal pilot surface or the pocket 246 of the finish blocks 216, 218. The core 244 includes a radially outward male feature 252, a radially inward male feature 254, and central male feature 256 therebetween. Similarly, the core 244 includes a radially outward female feature 258 for at least partially forming the depressible bar 26 of the containers of Figs. 1-3, and the core 244 further includes a radially inward female feature 260 for at least partially forming the cantilevered lug 28 of the containers 10, 110 of Figs. 1-3. Likewise, the pocket 246 of the finish blocks 216, 218 is further defined by a female feature 262 for at least partially forming the cantilevered lug 28. Accordingly, the core 244 cooperates with the pocket 246 to define the closure release 22 and the spaces between the neck finish 14 and the closure release 22 of the container 10 and ~~perform~~ preform 110 of Figs. 1-3.--

Cancel the paragraphs from page 10, line 12 through page 12, line 7, and replace with the following:

--Figs. 6-8 7 are directed toward an apparatus 300 according to an alternative embodiment of the present invention. Fig. 6 represents a top view of a finish block 310 and a mold body 312. The finish block 310 includes recessed threads 314, 316 for forming the threads 20 on the container 10 and preform 110 of Figs. 1-3. The finish block 310 further includes female features 318, 320 that partially define a cavity or pocket for partially forming the closure release 22 of the container 10 and preform 110 of Figs. 1-3.

Unlike the previously described embodiment, wherein the axial features are integrated into the mold bodies, this embodiment involves incorporating a unique actuator assembly 318 into the mold body 312. The actuator assembly 318 includes a cylinder 320 formed in a forward end 322 of the mold body 312, into which a connected piston 324 and rod 326 are disposed. A recessed retainer plate 328 is fastened over the cylinder 320 at the forward end 322 of the mold body 312 by fasteners 330 such as screws, and the like. The retainer plate 328 seals the piston 324 and rod 326 within the cylinder 320. A forward end 332 of the rod 326 is fixed to a core 334. Essentially, the core 334 includes the same or similar male and female features as the core 244 of Fig. 5, which features are not repeated in detail here. Nonetheless, the male and female features (not shown) of the core 334, together with the pocket ~~318, 320~~ 319, 321 of the finish block 310, are provided for forming the closure release 22 of the containers 10, 110 of Figs. 1-3.

Fig. 7 illustrates a side view of a die plate 336 and the mold body 312 of Fig. 6, wherein the piston 324, rod 326, and core 334 have been advanced from a home position, as in Fig. 6, into an advanced position as shown here wherein the core 334 of the

mold body 312 cooperates with the pocket ~~318, 320~~ 319, 321 of the finish block 310 to form the closure release 22 of the containers 10, 110 of Figs. 1-3. The actuator assembly 318 may be actuated to the advanced position by any manner wherein positive fluid pressure is supplied to a rearward side 338 of the piston 324 and may be retracted or reversed by applying vacuum or a negative pressure to the rearward side 338 of the piston 324 or a positive pressure to a forward side 340 of the piston 324. Related equipment and features for the actuator assembly 318 such as a pump, a fluid supply, and fluid passages formed in the mold are well known in the art and, thus, are not shown here.

In general, a method is provided according to the present invention for injection molding an article. A plurality of finish blocks is provided, wherein one or more of the plurality of finish blocks includes one or more pockets. A plurality of mold bodies are provided, wherein one or more of the plurality of mold bodies includes one or more core portions that cooperate with the pockets of the plurality of finish blocks. The core portion may be integrally formed in the plurality of mold bodies, as described above with respect to Figs. 4A-5. The core portion may also be separately attached and actuated within the plurality of mold bodies, as described above with respect to Figs. 6-8 7. Other alternative core arrangements are contemplated by, and well within the scope of, the present invention. The plurality of finish blocks are then closed together to form a neck-finish mold cavity and the plurality of mold bodies are closed together to form a body mold cavity. The core portion is advanced toward the plurality of finish blocks and cooperates with the pocket to define a cavity for forming a radially extending element of the article. The core portion is retracted from out of cooperation with the pocket, before the mold bodies are

separated from one another, thereby avoiding damage to the closure release of the article.-

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